

Split

Work Order ID 58205-1

Thursday, April 29, 2010 10:36:43 AM



Page 1

Item ID: D3637-041

Accept



Setup Start



Revision ID:

Item Name: Bracket Assembly



Start Date: 4/29/2010 Start Qty: 10.00



Required Date: 5/14/2010 Req'd Qty: 10.00



Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: MF

Date: 10-4-29

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/

Work Center ID

Operation

Description

Draw Nbr

Revision Nbr

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

D3637

Rev B

0.00

100

FLOW WATER JET



Waterjet

FLOW CNC Waterjet

3634 . 080

Memo

0.00

1-Cut as per Dwg D3637

Dwg Rev:

Prog Rev: B

2-

B

B

10-4-29

(14)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Quality Control

Memo

0.00

10-4-29

120

QC8- Inspect parts - second check

0.00

QC

Quality Control

Memo

0.00

10-4-29

(14)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

**Work Order ID 58205**

Thursday, April 29, 2010 10:36:43 AM



Page 2

Item ID: D3637-041

Accept



Setup

Start



Stop



Revision ID:

Item Name: Bracket Assembly

Start Date: 4/29/2010 Start Qty: 10.00



Required Date: 5/14/2010 Req'd Qty: 10.00



Reference:

Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Tooling:

Date:

Run

Start



Stop

Sequence ID/  
Work Center IDOperation  
Description

Date:

SPC (Y/N):

Date:

Run

Start



130



Brake NC

NC BRAKE

Set Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

88 10/04/03

14 8

Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

1- drill holes as per dwg using DT8979 2-C'Sink as per Dwg D3637  
Install Nut plate as per Dwg D36373-  $\Rightarrow$  m. k w/05/10

150



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

Siosus/10

x2

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

**Work Order ID 58205**

Thursday, April 29, 2010 10:36:43 AM



Page 3

Item ID: D3637-041

Accept

Revision ID:

Item Name: Bracket Assembly

Start Date: 4/29/2010 Start Qty: 10.00



Required Date: 5/14/2010 Req'd Qty: 10.00



Reference:

Approvals: Process Plan:

QC:

Sequence ID/  
Work Center ID

160



Packaging

Packaging

Operation  
Description

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

Memo

Date:

Tooling:

Date:

Run

Start



Date:

SPC (Y/N):

Date:

Stop

Set Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
StampPP  
58488

0.00

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/05/10 HJ

MF  
10-5-10

Accept

Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Eric/010

(2)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

# Picklist Print

Thursday, April 29, 2010 10:36:42 AM

Page 1

Work Order ID: 58205

Parent Item: D3637-041

Parent Item Name: Bracket Assembly

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC  
IPP Rev:B change to REV.B as per dwg 08-02-11 DD verified by:ec

Start Date: 4/29/2010

Start Qty: 10.00

Required Date: 5/14/2010

Required Qty: 10.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch<br>Purchased | Bin<br>Item<br>No | Primary<br>Location | Last<br>Location | Route<br>Seq ID<br>100 | Unit of<br>Measure<br>Each | Qty on<br>Hand<br>5,068.000 | Qty per Kit<br>2 | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|----------------------------|-------------------|---------------------|------------------|------------------------|----------------------------|-----------------------------|------------------|---------------|----------------|--------|
|---------------------------------|------------------------|----------------------------|-------------------|---------------------|------------------|------------------------|----------------------------|-----------------------------|------------------|---------------|----------------|--------|

Rivet

M304S14GA



304SS sheet .080

Purchased

| Location | Loc Qty  | Loc Code |
|----------|----------|----------|
| ST316    | 5068     |          |
| 19099    | 4774     |          |
| 7681 ✓   | 294      |          |
| No       | 140      | sf       |
|          | 138.6608 |          |
|          | 0.09     |          |

28 m/h 10/05/10

MS21059L4



Nutplate

Purchased

| Location | Loc Qty  | Loc Code |
|----------|----------|----------|
| MAT20    | 138.6608 |          |
| 113295   | 138.6608 |          |
| No       | 140      | Each     |
|          | 37.0000  |          |

130-4-28

14

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST302    | 37      |          |
| 112243 ✓ | 37      |          |

14X m/h  
10/05/10

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

|                       |              |             |
|-----------------------|--------------|-------------|
| DART AEROSPACE LTD    | Work Order:  | 58205       |
| Description: Bracket  | Part Number: | D3637-1     |
| Inspection Dwg: D3637 | Rev: B       | Page 1 of 1 |

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

|              |         |             |          |                     |     |
|--------------|---------|-------------|----------|---------------------|-----|
| Measured by: | B       | Audited by: | S        | Prototype Approval: | N/A |
| Date:        | 10-4-29 | Date:       | 10/07/30 | Date:               | N/A |

| Rev | Date     | Change    | Revised by    | Approved  |
|-----|----------|-----------|---------------|---|
| A   | 08.04.15 | New Issue | P/O D3637-041 | KJ/DD   |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

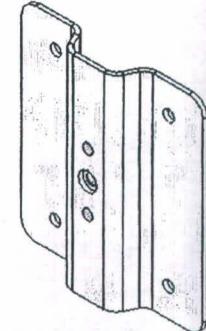
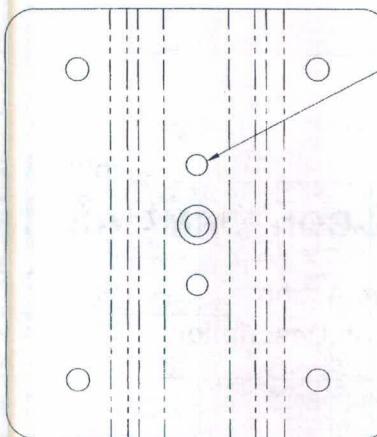
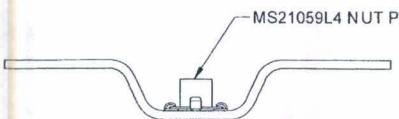
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D



D3637-041 BRACKET ASSEMBLY  
(WAS GENEVA P/N G10602-1)

D3637-041 PARTS:

| QTY | P/N          | DESCRIPTION      |
|-----|--------------|------------------|
| X   | D3637-041    | BRACKET ASSEMBLY |
| 1   | D3637-1      | BRACKET          |
| 1   | MS21059L4    | NUTPLATE         |
| 2   | MS20426AD3-3 | RIVET            |

D3637-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.27 lbs

8 7 6 5 4 3 2 1

|            |   |                             |          |
|------------|---|-----------------------------|----------|
| B          | FOR D3637-1, 115 WAS 130 & 'REF' REMOVED FROM ANGLE | LE                          | 07.12.18 |
| A          | NEW ISSUE; REPLACES G10608, G10602 & G10609         | LE                          | 07.07.27 |
| REV.       | DESCRIPTION   | BY                          | DATE     |
| DESIGN     | TS  | DART AEROSPACE LTD          |          |
| DRAWN      |   | HAWKESBURY, ONTARIO, CANADA |          |
| CHECKED    |   | REV. B                      |          |
| MFG. APPR. |   | DRAWING NO. D3637           |          |
| APPROVED   |   | SHEET 1 OF 3                |          |
| DE APPR.   |   | TITLE                       | SCALE    |
| DATE       | 07.12.18  | BRACKET                     | 1:1      |

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8 7 6 5 4 3 2 1

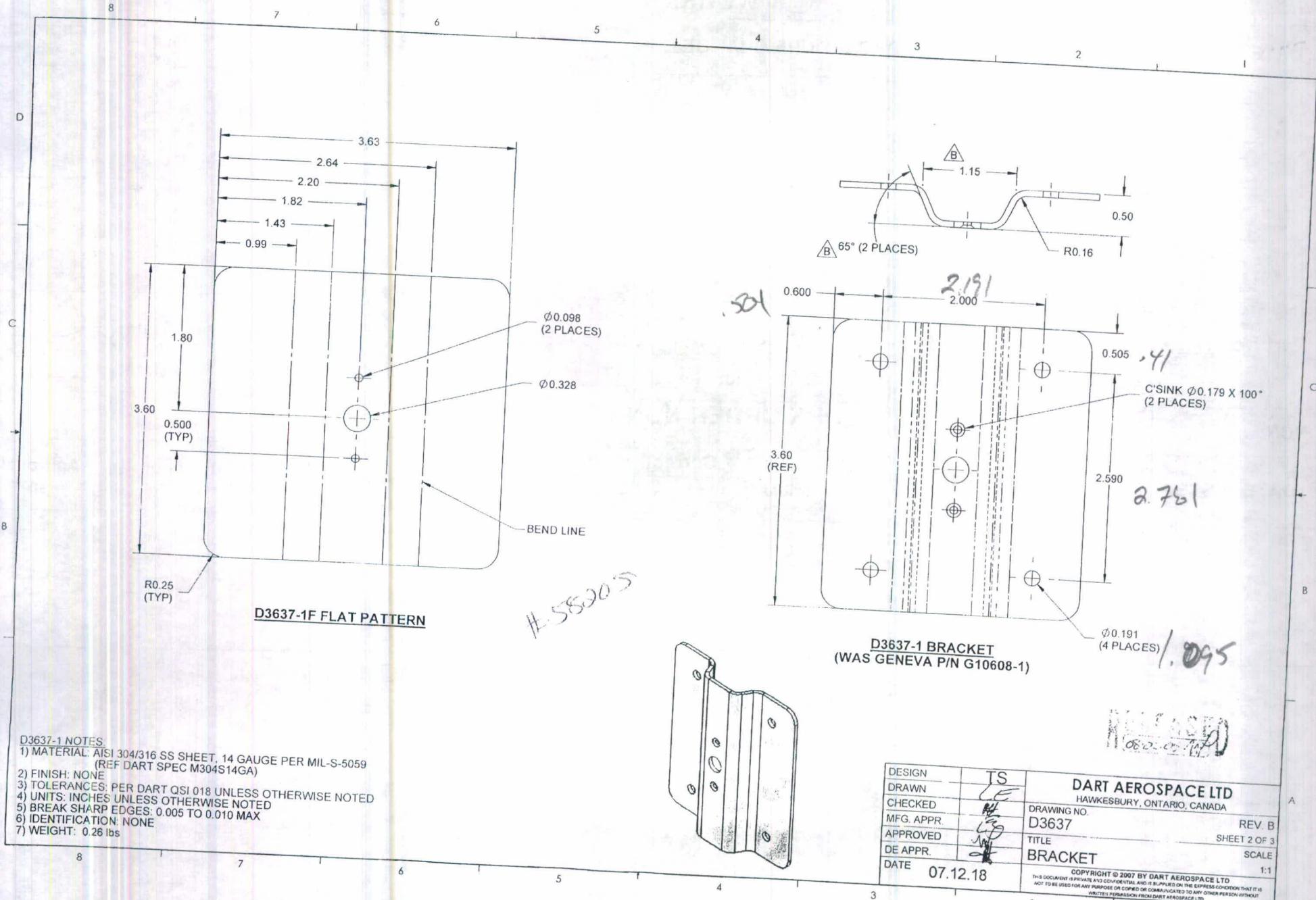
1

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

D

D

C

C

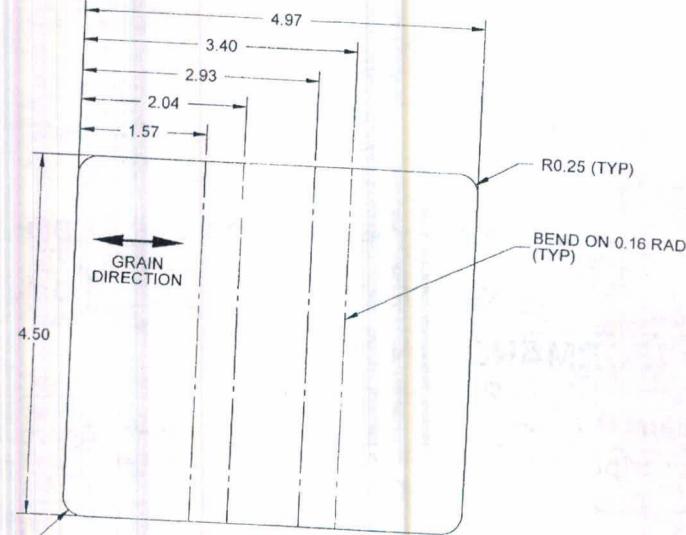
B

B

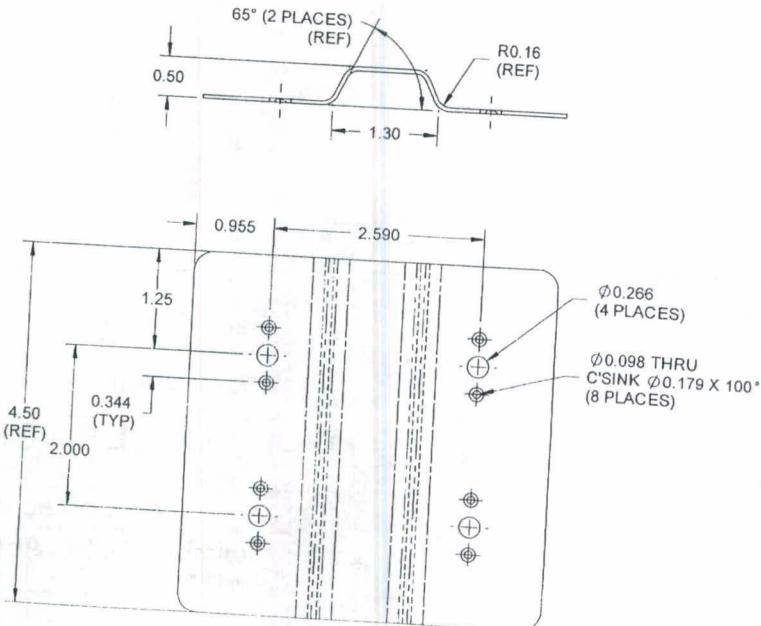
A

A

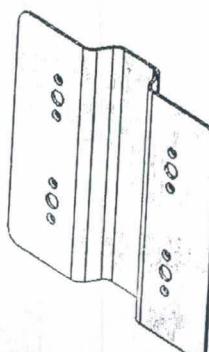
R0.25 (TYP)



D3637-3F FLAT PATTERN

D3637-3 BRACKET  
(WAS GENEVA P/N G10609-1)

#58203



|              |          |                             |
|--------------|----------|-----------------------------|
| DESIGN DRAWN | TS       | DART AEROSPACE LTD          |
| CHECKED      | PT       | HAWKESBURY, ONTARIO, CANADA |
| MFG. APPR.   | CD       | DRAWING NO.                 |
| APPROVED     | W        | D3637                       |
| DE APPR.     |          | REV. B                      |
| DATE         | 07.12.18 | SHEET 3 OF 3                |
|              |          | SCALE                       |
|              |          | 2:3                         |

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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries